

Work Order ID 71553

Wednesday, July 06, 2011 11:57:46 AM



Page 1

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 7/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 4.00



Customer:

Reference:

[Signature]

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2572

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

Program Batch No. 71553

Double check by: [Signature]

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

OK 11/07/08

4 0

110

0.00



CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Memo

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

OK 11/07/08

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				4	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				4	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00							

ML 11/07/08

B.A 11/07/12

H BH 11-7-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 71553

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Item ID: D2572

Accept



Setup Start



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Item Name: Saddle, Fwd In 205

Start Date: 7/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

1:15
1:32
1:45

4X0 MA 11/07/12

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

H 0 BL 11-7-12

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

PC 4/13 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71553

Wednesday, July 06, 2011 11:57:46 AM



Page 4

Item ID: D2572

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Setup Start



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Item Name: Saddle, Fwd In 205

Start Date: 7/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

M/7/13

ME

11-07-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 11:57:43 AM

Page 1

Work Order ID: 71553

Parent Item: D2572

Parent Item Name: Saddle, Fwd In 205



Start Date: 7/6/2011

Required Date: 7/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: 1102.10.0211 Re-format; Change to Dwg Rev. D & incorporated D257211KJ11

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	49.0000	1	4			

Saddle Billet

Location

Loc Qty

Loc Code

MAT045

38 ~~20~~

~~66966~~

~~18~~

70676

20

MAT046

11

65382

4

→ 65953

4

~~66966~~

3

4 and 11/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71553
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

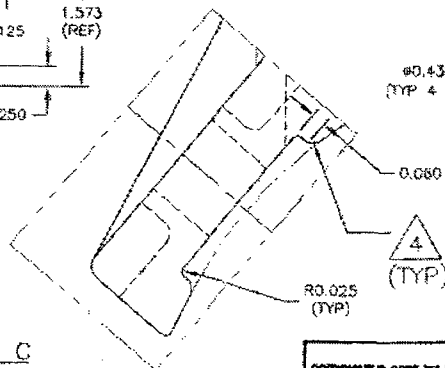
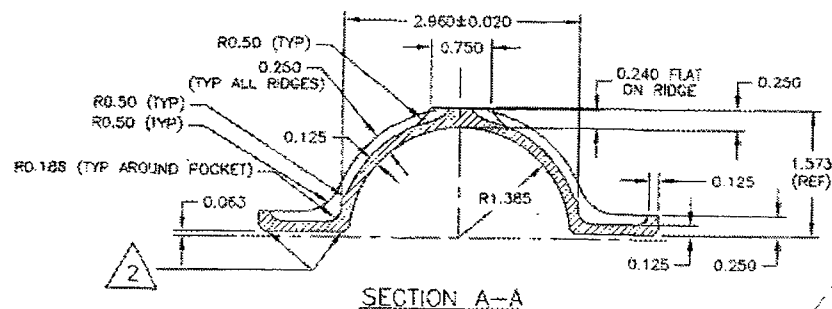
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.443	.443	.443	.440		
B	1.745	1.755		1.748	1.748	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.748	1.749	1.749		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		.501	.503	.501	.502		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.499	.499	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.567	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.494	1.493	1.494		
N	2.495	2.505		2.499	2.500	2.499	2.499		
O	3.869	3.879		3.872	3.873	3.873	3.873		
P	0.115	0.135		.124	.124	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.247	.250	.250	.251		
S	0.115	0.135		.131	.127	.127	.136		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.236	.237	.241	.242		
W	0.115	0.135		.124	.127	.126	.128		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.761	.760	.761	.760		
Z	0.352	0.372		.370	.367	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.626	.626	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.244	.245	.249	.247		
AE	1.375	1.395		1.385	1.388	1.382	1.381		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.265	.260	.260	.260		
AH	0.240	0.260		.246	.247	.251	.251		
AI	2.000	2.020		2.003	2.005	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>one</i>
Date:	11/07/07





Audited by:	B.A
Date:	11/07/12

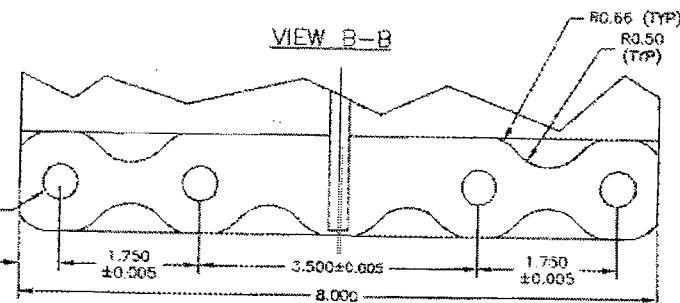
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

05.12.06



MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC D6H02-Q03)
FINISH: ACID ETCH, ALODINE PER DART Q05 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART Q01 Q05 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART Q01 Q18 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063 x 45° ALL AROUND |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C) |



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCOMP. DEC 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR.. 0.438 WAS C 425
A	96.09.16	NEW ISSUE

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. MANICOMBERT, ONTARIO, CANADA
DS	PH		
CHECKED 	APPROVED 	DRAWING NO.	REV.
		D2572	SHEET 1 OF
DATE		TITLE	SCALE
05.07.13		INNER FWD SADDLE	2: